

Work Order ID 64694

Tuesday, December 14, 2010 1:09:42 PM



Page 1

Item ID: D120-638-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 12/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10/21/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

Sub 107/107

CK 11/01/06

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/16 SP 20

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sub 107/107

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD120-638-011 Location: <u>B</u> <u>Reva</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/14/10 @ 28

CK 11/01/07
MF
11-01-07

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1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

Required Date: 12/22/_010

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2435 		Manufactured	No			160	Each	0.0000	2	4			
Bearpaw, 206 D2182B050 		Manufactured	No			160	Each	6.0000	4	8			
Clamp Cushion Black <i>x4 @ 5.0" - measured 5.16167</i>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		6							
				63470		6							
D2274 		Manufactured	No			160	Each	25.0000	8	16			
Radius Block													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		25							
				61361		1							
				63990		24							
D2438 		Manufactured	No			160	Each	3.0000	4	8			
Clamp													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST456		3							
				60852		3							

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Picklist Print

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Work Order ID: 64694

Parent Item: D120-638-011

Parent Item Name: Bearpaw



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2529

Manufactured No

160

Each

927.0000

8

16



Washer



11/1/16 SP

Location

Loc Qty

Loc Code

ST017

927

64127

927

10

AN4-15A

Purchased

No

160

Each

203.0000

8

16



Bolt



11/1/16 SP

Location

Loc Qty

Loc Code

ST358

203

114784

9

115108

5

115371

5

115936

184

16

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

30.0000

8

16



Washer



11/1/16 SP

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64694

Parent Item: D120-638-011

Parent Item Name: Bearpaw



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

4,634.000

8

16



Nut



11/16 SP 20

Location

Loc Qty

Loc Code

ST300

4634

1123143

2

115589

32

115621

1100

116188

3500

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

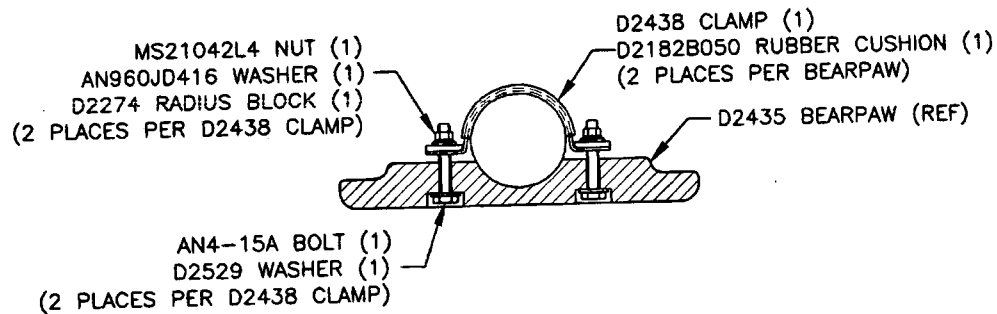


Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)